

Date: Thursday, 16/04/2009 1:43:08 PM
 User: Julie Dawson

Process Sheet

| | | | | | | | | |
|----------------------------------|---------------------------------------|------------|---------------------|--|---------------|--|--|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : SADDLE FITTING, AFT (OUTBOARD/INBOARD) | | | | |
| Job Number | : 47250 | | | | | | | |
| Estimate Number | : 10534 | | | | | | | |
| P.O. Number | : | | | Part Number | : D2574 | | | |
| This Issue | : 16/04/2009 | S.O. No. : | | Drawing Number | : D2574 REV E | | | |
| Prsht Rev. | : NC | | | Project Number | : N/A | | | |
| First Issue | : / / | Type : | | Drawing Revision | : E | | | |
| Previous Run | : 46955 | | | Material | : | | | |
| Written By | : | | | Due Date | : 23/04/2009 | | | |
| Checked & Approved By | <u>JL</u> 09/04/19 | | | Qty: | 4 | | | |
| Comment | : Est Rev: I As Per RevE 06-01-27 JLM | | | Um: | Each | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|--|--------------------|
| 1.0 | D6101005 | Saddle Billet | |
| | | | |
| | | Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: <u>B46A11</u> | |
| 2.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 | |
| | | | |
| | | Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: <u>B47250</u> Double check by: <u>JL</u> | |
| | | 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges. | |
| 3.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE | |
| | | | |
| | | Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574 | <u>JL</u> 09/04/19 |
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | |
| | | | |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | <u>JL</u> 09/04/19 |
| | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 16/04/2009 1:43:08 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 47250

Part Number: D2574

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK



09/04/19 (4)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

09-04-20 X4

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 M10939

START TIME: 12:00

OVEN TEMPERATURE: 320°

FINISH TIME: 12:30

(4)

BL 09-04-20

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

S 09/04/20 X4

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Sty34

F 09/04/20 (4)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



09/04/22 (4)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf
09-04-21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

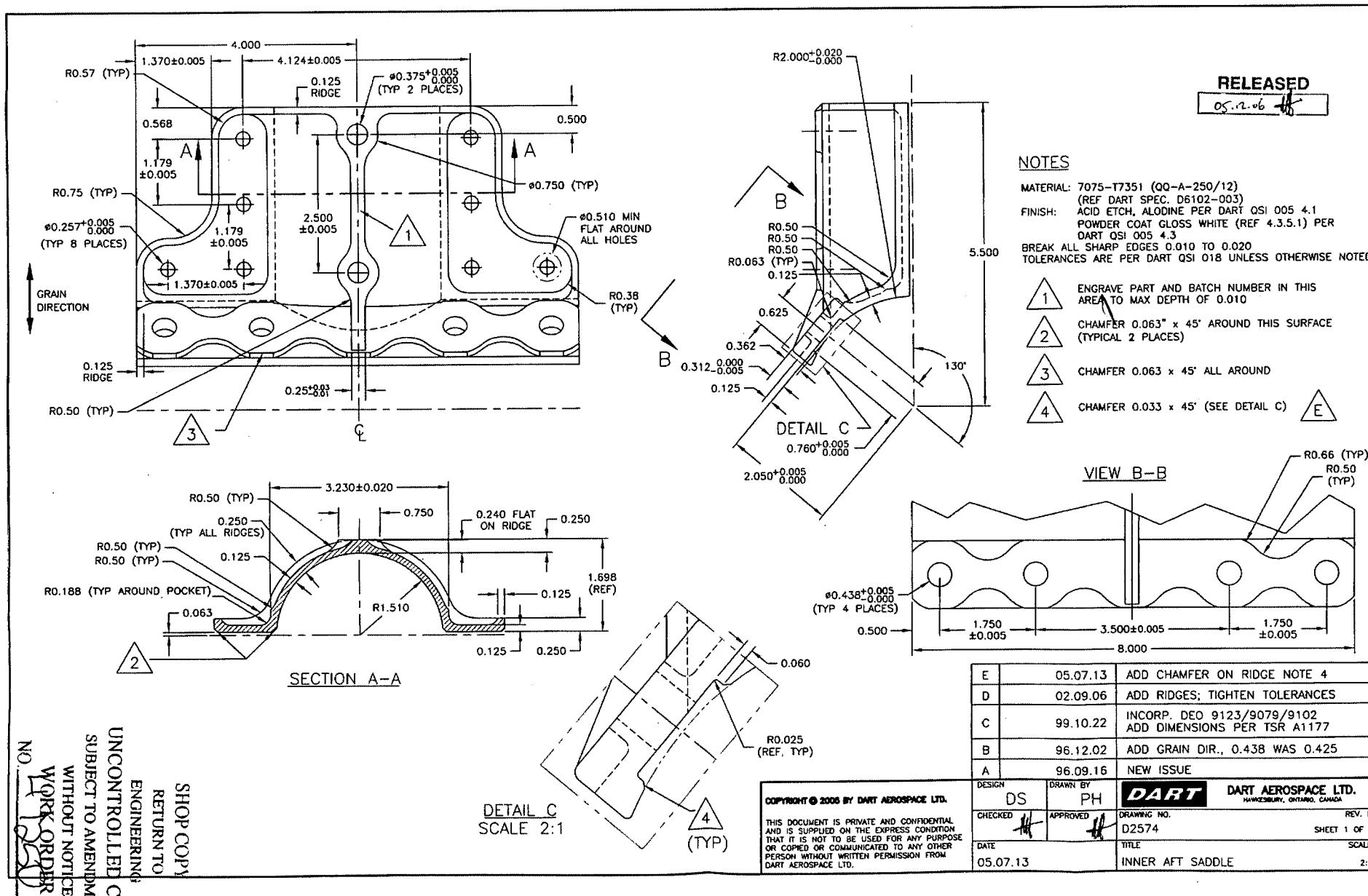
| | | |
|----------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 47250 |
| Description: Saddle, Aft Inboard | Part Number: | D2574 |
| Inspection Dwg: D2574 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| | | | | 1 | 2 | 3 | 4 | | |
| A | 0.438 | 0.443 | | .440 | .440 | .440 | .440 | | |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.500 | | |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| E | 7.990 | 8.010 | | 7.999 | 8.000 | 7.999 | 8.000 | | |
| F | 0.490 | 0.510 | | .499 | .495 | .498 | .491 | | |
| G | 0.257 | 0.262 | | .259 | .259 | .259 | .259 | | |
| H | 0.375 | 0.380 | | .376 | .376 | .376 | .376 | | |
| I | 0.490 | 0.510 | | .503 | .504 | .502 | .502 | | |
| J | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| K | 0.558 | 0.578 | | .570 | .570 | .571 | .570 | | |
| L | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| M | 1.365 | 1.375 | | 1.370 | 1.370 | 1.370 | 1.370 | | |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| O | 4.119 | 4.129 | | 4.124 | 4.124 | 4.124 | 4.124 | | |
| P | 0.115 | 0.135 | | .125 | .125 | .125 | .125 | | |
| Q | 0.115 | 0.135 | | .135 | .135 | .135 | .135 | | |
| R | 0.240 | 0.260 | | .252 | .252 | .252 | .252 | | |
| S | 0.115 | 0.135 | | .126 | .126 | .127 | .130 | | |
| T | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | | |
| U | 3.210 | 3.250 | | 3.230 | 3.230 | 3.230 | 3.230 | | |
| V | 0.230 | 0.250 | | .240 | .240 | .239 | .239 | | |
| W | 0.115 | 0.135 | | .127 | .125 | .126 | .127 | | |
| X | 0.307 | 0.312 | | .310 | .311 | .310 | .310 | | |
| Y | 0.760 | 0.765 | | .760 | .760 | .760 | .760 | | |
| Z | 0.352 | 0.372 | | .363 | .361 | .361 | .365 | | |
| AA | 0.470 | 0.530 | | .500 | .500 | .500 | .500 | | |
| AB | 0.615 | 0.635 | | .627 | .629 | .627 | .627 | | |
| AC | 0.053 | 0.073 | | .063 | .063 | .063 | .063 | | |
| AD | 0.240 | 0.260 | | .245 | .248 | .245 | .248 | | |
| AE | 1.500 | 1.520 | | 1.517 | 1.516 | 1.516 | 1.516 | | |
| AF | 0.115 | 0.135 | | .135 | .135 | .135 | .135 | | |
| AG | 0.240 | 0.280 | | .260 | .260 | .260 | .260 | | |
| AH | 0.240 | 0.260 | | .248 | .247 | .247 | .248 | | |
| AI | 2.000 | 2.020 | | 2.005 | 2.005 | 2.005 | 2.005 | | |
| AJ | 0.023 | 0.043 | | .033 | .033 | .033 | .033 | | |
| Accept/Reject | | | | | | | | | |

| | | | |
|--------------|----------|-------------|----------|
| Measured by: | J.L | Audited by: | R.P. |
| Date: | 09/04/18 | Date: | 09/04/19 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.27 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | JLM |



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